

Date: Wednesday, 6/6/2007 1:59:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BATTERY LOCK ASSEMBLY
Job Number : 32807	
Estimate Number : 10900	
P.O. Number : <i>N/A</i>	Part Number : D3393041
This Issue : 6/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3393- UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31667	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 6/20/2007
Checked & Approved By : <i>[Signature]</i> 07.06.07	Qty: 2 Um: Each
Comment : Est Rev. New Issue 05-11-22 JLM	

*PLEASE REMOVE
 AS DWG IS NOW
 UNDER REVIEW
 07.06.07*

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D27287	Decal
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Decal	<i>B22554-</i>

2.0	D33731	Cam Lock
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3373-1 <i>KA</i>	Cam Lock	<i>INVENTORY B23643</i>

3.0	516WC	SS Flat Washer 5/16
-----	-------	---------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	5/16WC	SS Flat Washer	<i>M103165-</i>

4.0	D33931	Battery Lock Casing
-----	--------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3393-1	Battery Lock Casing	<i>B23552</i>

PC 7/6/11 (2)

N/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 32807

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

B2 3536

2 7/8/4 (2)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

M 100410

PTO

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- 0420 A

5- _____

2- C 420 A

6- _____

3- _____

7- _____

4- _____

8- _____

M 07/06/12 x2

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

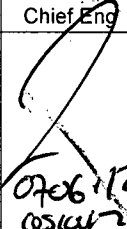
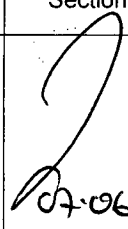

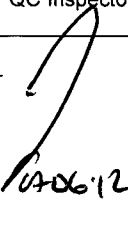
SS Rod

M 102756

M 07-06-12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/12	6	let parts felt down shipped as new chipped side of D3393-3 Broke two D3373-1		Scraped these parts and replace by new one. Put one additional Washer AN 960 C616L M18822	ml 07/06/12			

NOTE: Date & initial all entries

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Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 32807

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/06/13 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/06/13 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

107/06/14 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

107/06/14

Job Completion



107/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

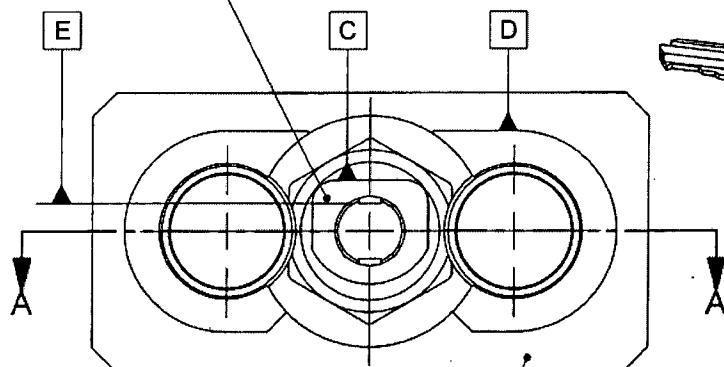


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08	TITLE BATTERY LOCK		SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED

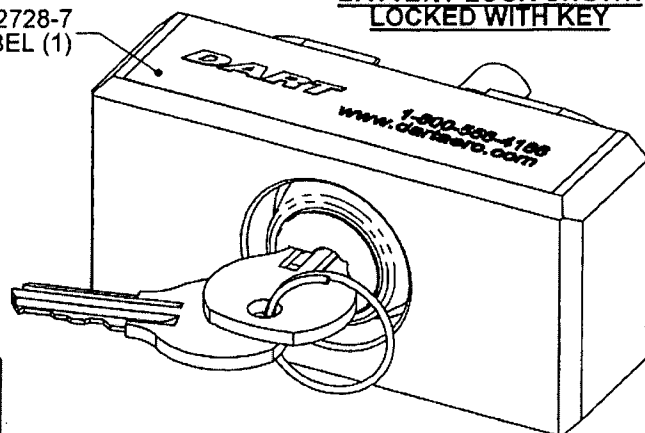
05/03/09

POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D2728-7
LABEL (1)

BATTERY LOCK SHOWN
LOCKED WITH KEY



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: MCMASTER-CARR, P/N 9567K21

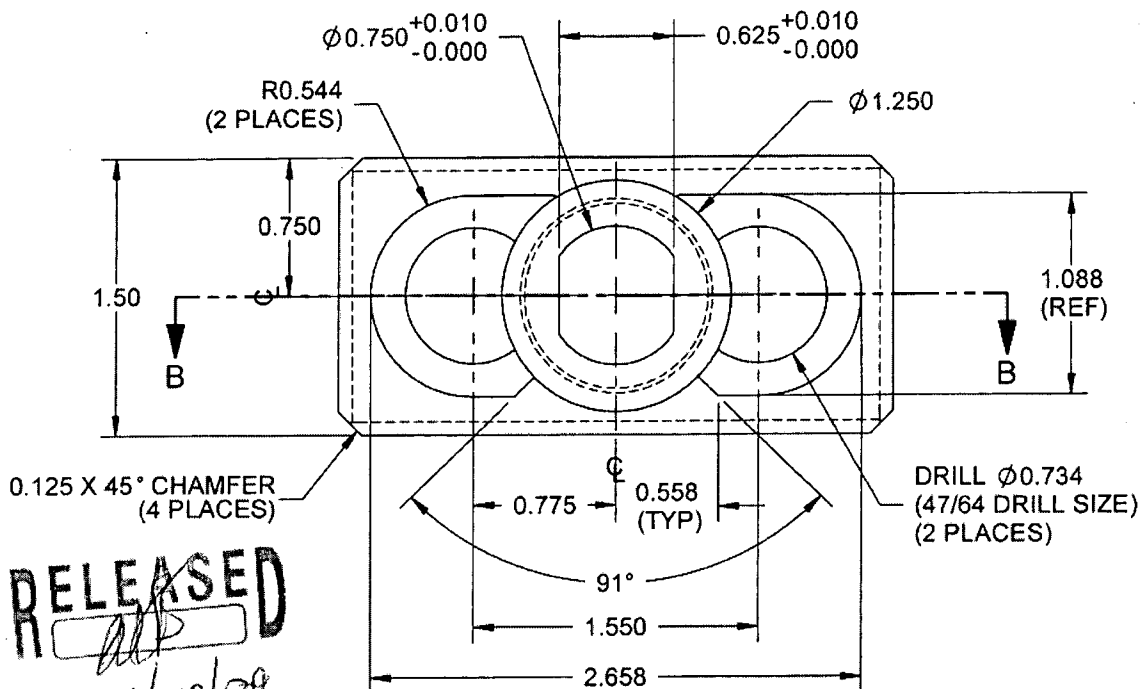
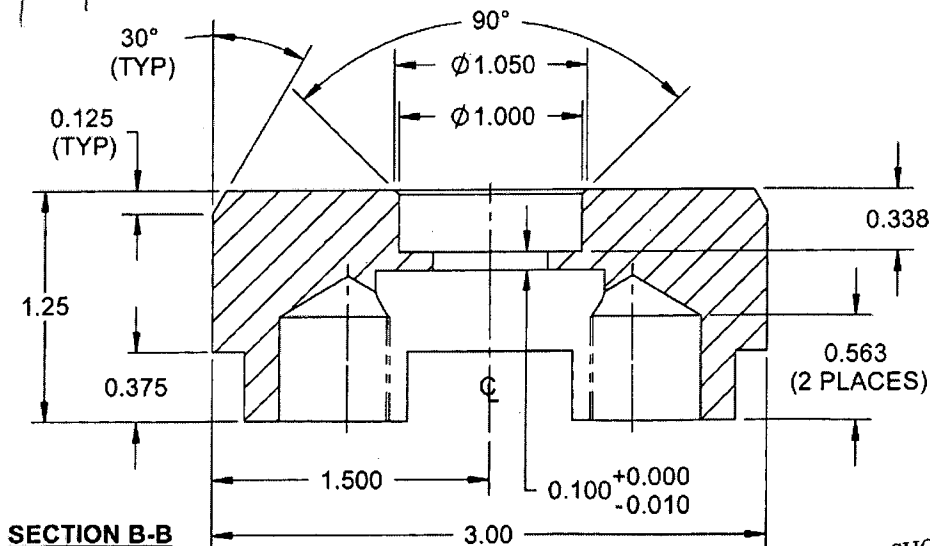
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DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TH	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1

**RELEASED**
05/03/09**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

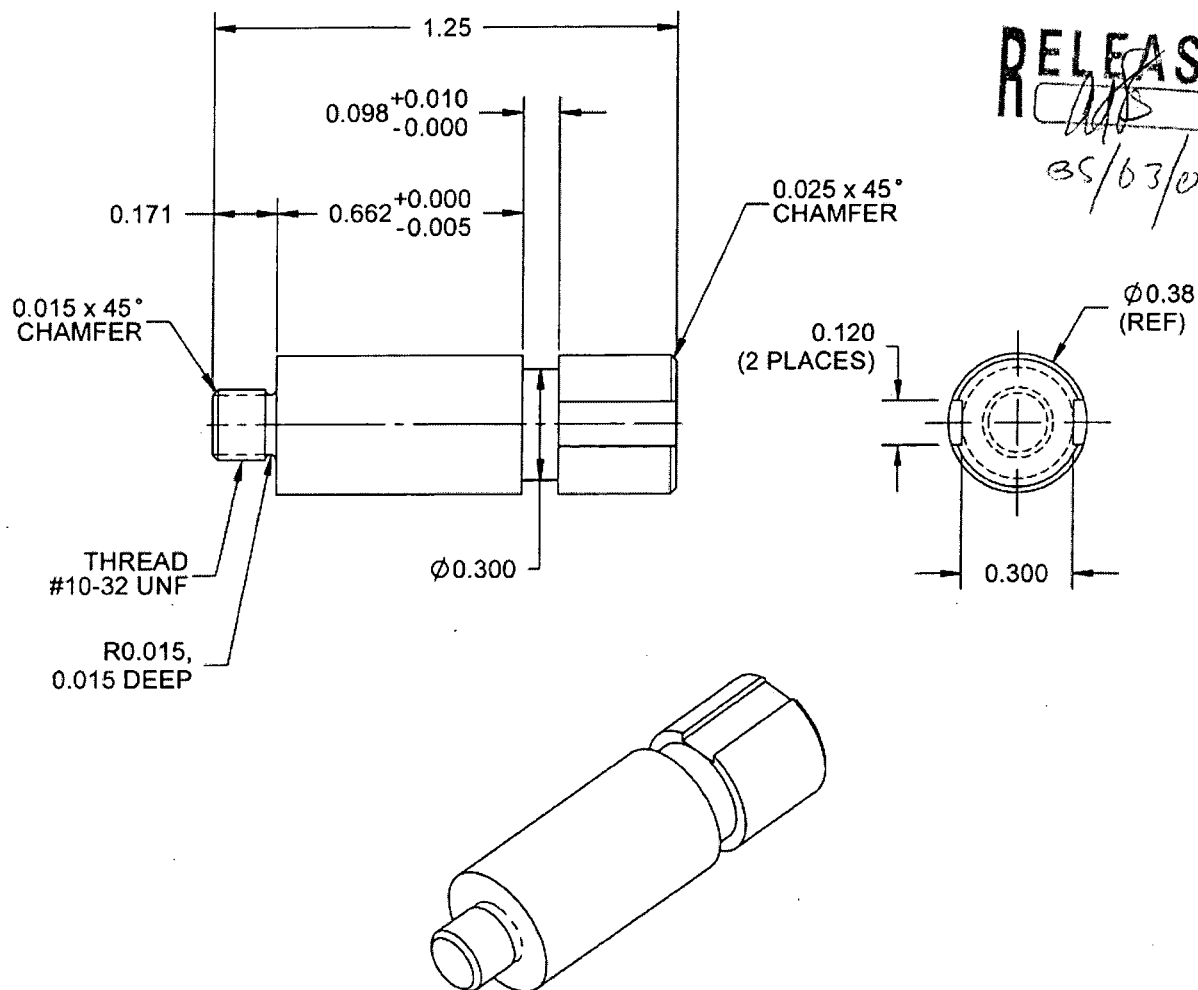
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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